Let's work on the pronunciation of Miku V4 English! Miku's second English voicebank was released about three years after the first, with Saki Fujita working on her English skills between the two releases, and it shows. Many of V3's problems were removed or reduced with V4's release. However, many other things remained problems or new problems came up as well. So let's look at how to patch some of these up!
Miku V3 English Pronunciation Guide! For my guide on V3.

Intrusive R

This is much less of a problem than in her Vocaloid3 version, but it still crops up occasionally. It's usually in such a way that a "w" in between will fix it, so it's generally easier than V3's case.

Ls

Miku's Ls are less of a problem 2016 onward and can actually be pretty nice, around Kaito's level if not even better! However, sometimes her old ways sneak in. Usually switching between [l] and [l0] is enough though.

Vowels

Miku's vowels tend to be clear and plain, which is a blessing and a curse. For example, her [V] phoneme is much more consistent than it used to be, but her vowels also tend to be a bit tense. For example:

-The distinction between [I] and its stressed version [i:] is even less than V3's case; pretty much near-non-existent in fact. You'll often want to replace [I] with [I e] or [e] (sometimes [eI]).
-[U] and [u:] are also less distinct from each other. [u: V] is a good replacement if [U] sounds too much like [u:].
-Like in V3's case, [V] [i:] is a cool-sounding replacement for [aI]. [e] [i:] can also be used for [eI] if the latter is too indistinct.

R-colored vowels

R-colored vowels are something Miku V4 English can struggle with, especially if you speak a rhotic dialect like I do (I'm from the US). I usually don't do much about Miku's lack of Rs, although...
-If the R-colored vowel follows another vowel, placing an [r] between them could bring out that R more. For example, the phrase "tear in my heart"- [t e@] [r I n] [m aI] [h Q@ t].

Consonants

Some of Miku's consonants can be kind of strange.

-Can occasionally slightly lisp on [s], but this is no big deal, a lot of vocaloids tend to lisp anyway. However, her [z] can be quiet at times. In that case, replacing it with [s] should make it clearer.
-Her [N] can sound quite a bit like a regular [n], or at least doesn't have much [g] in it. If you want to fix that, you could put a G at the end. Doubling the [N] might also have a different effect.
-In the case her [r] sounds tapped, you could replace it with a small [@r] or [@r r].

Other

For some reason, she occasionally releases hard consonants with a "y" sound. For example, she pronounces "car" like "kyar" by default. Usually switching between consonant "types" helps. It's kind of cute to hear her say "kyartoon" and "kyardigan" though.

Occasionally has odd vowel-consonant transitions, e.g. "have" can come out like "hawve" or "harve"- in that case, place a Silence between the vowel and consonant- [h { Sil v].